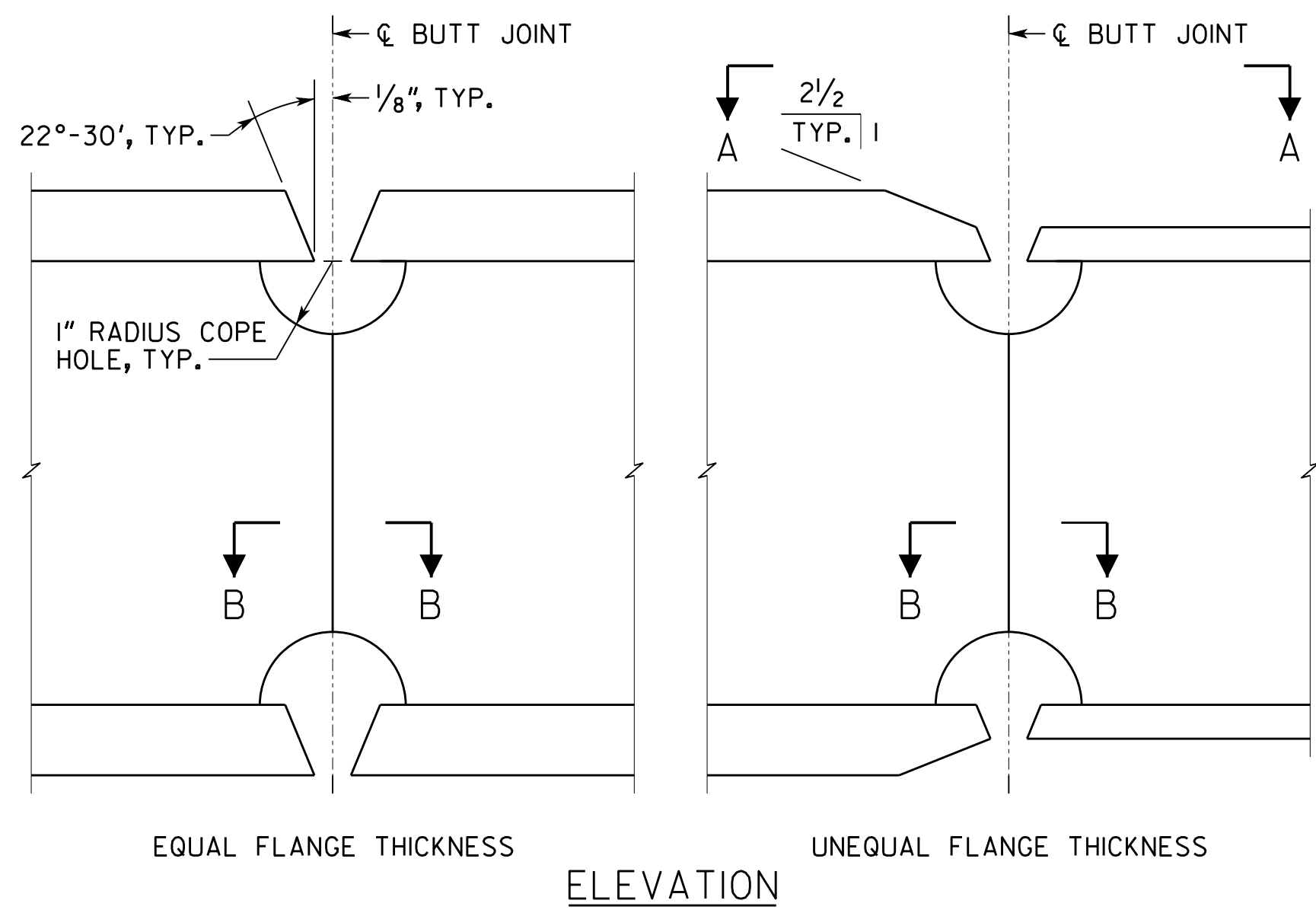


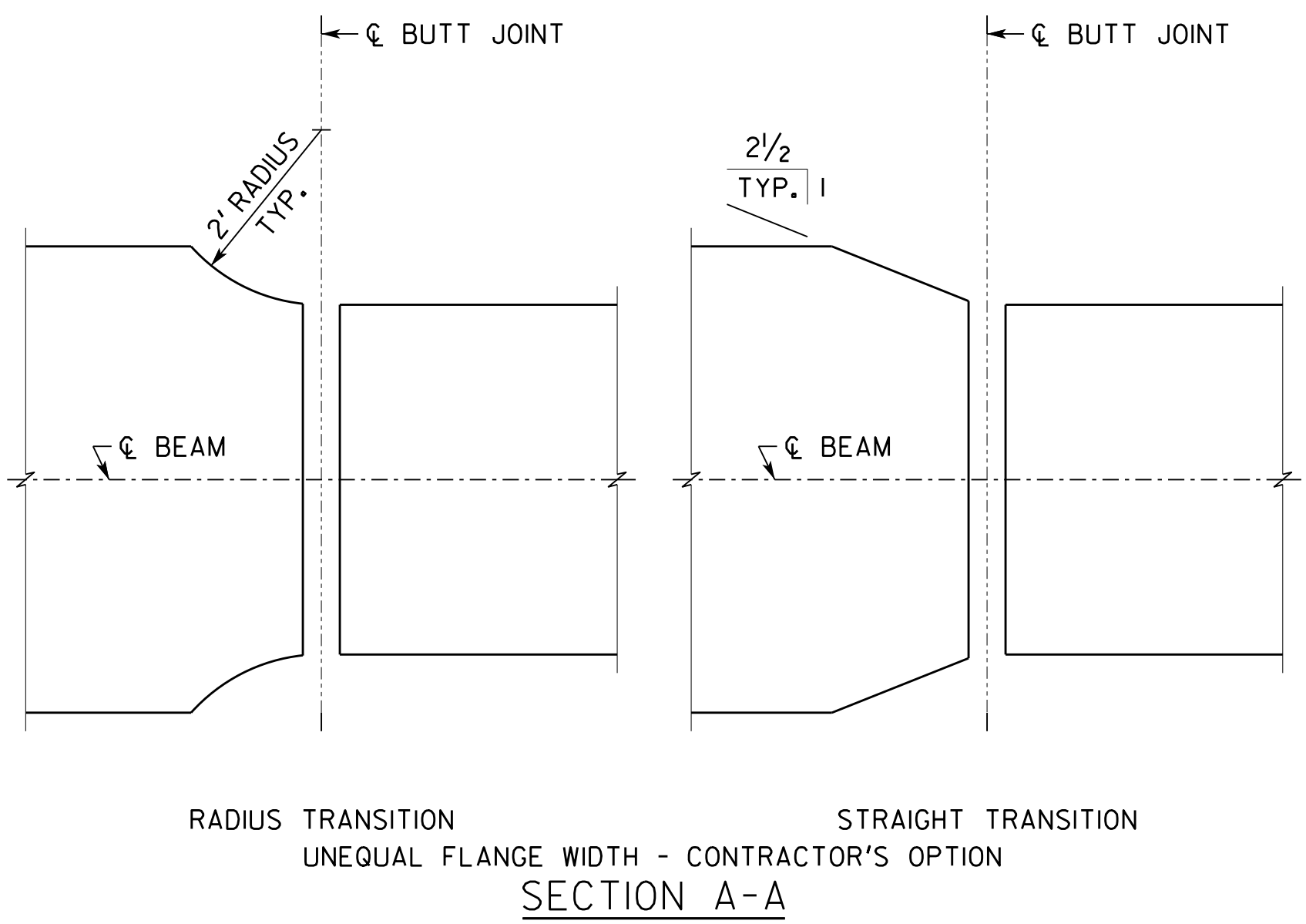
11/29/2015 AM

5/23/2009

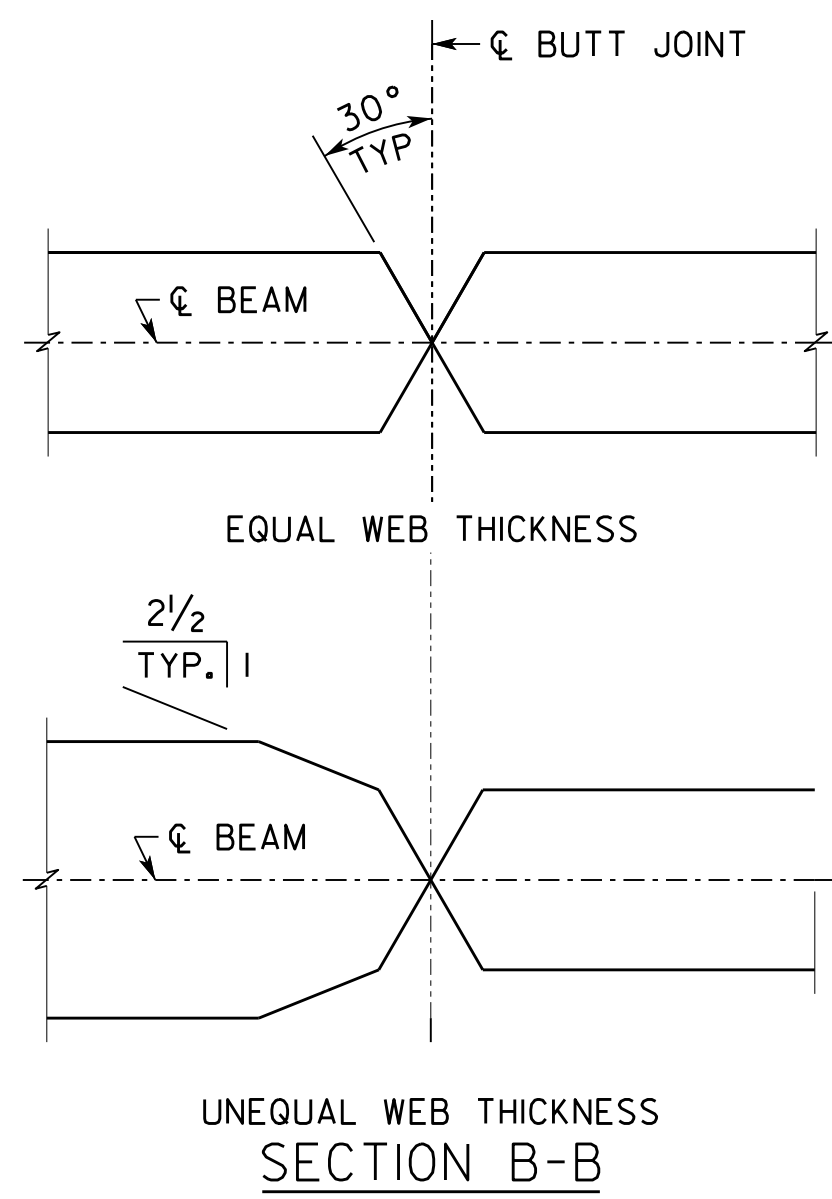
01020305



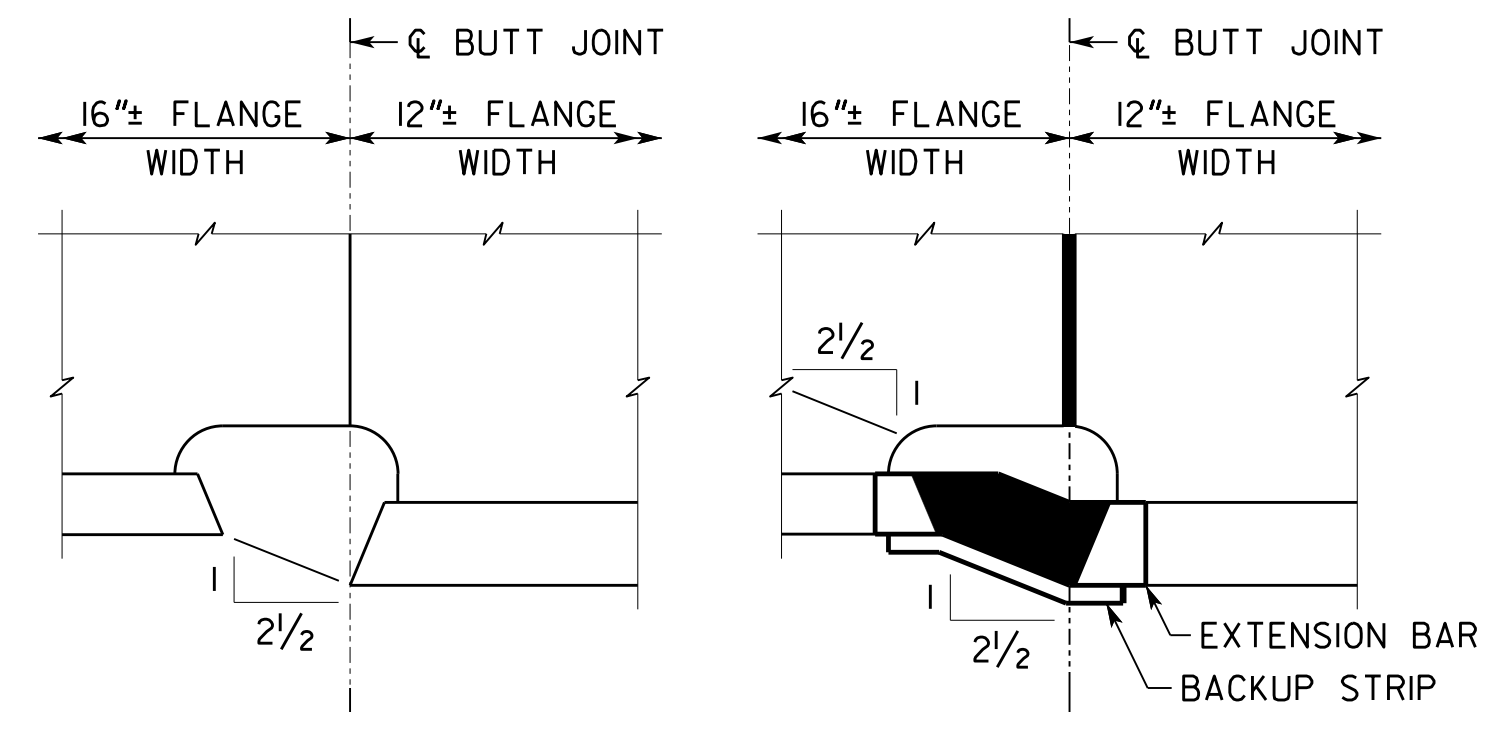
ELEVATION



SECTION A-A



SECTION B-B



SHOP PREPARATION

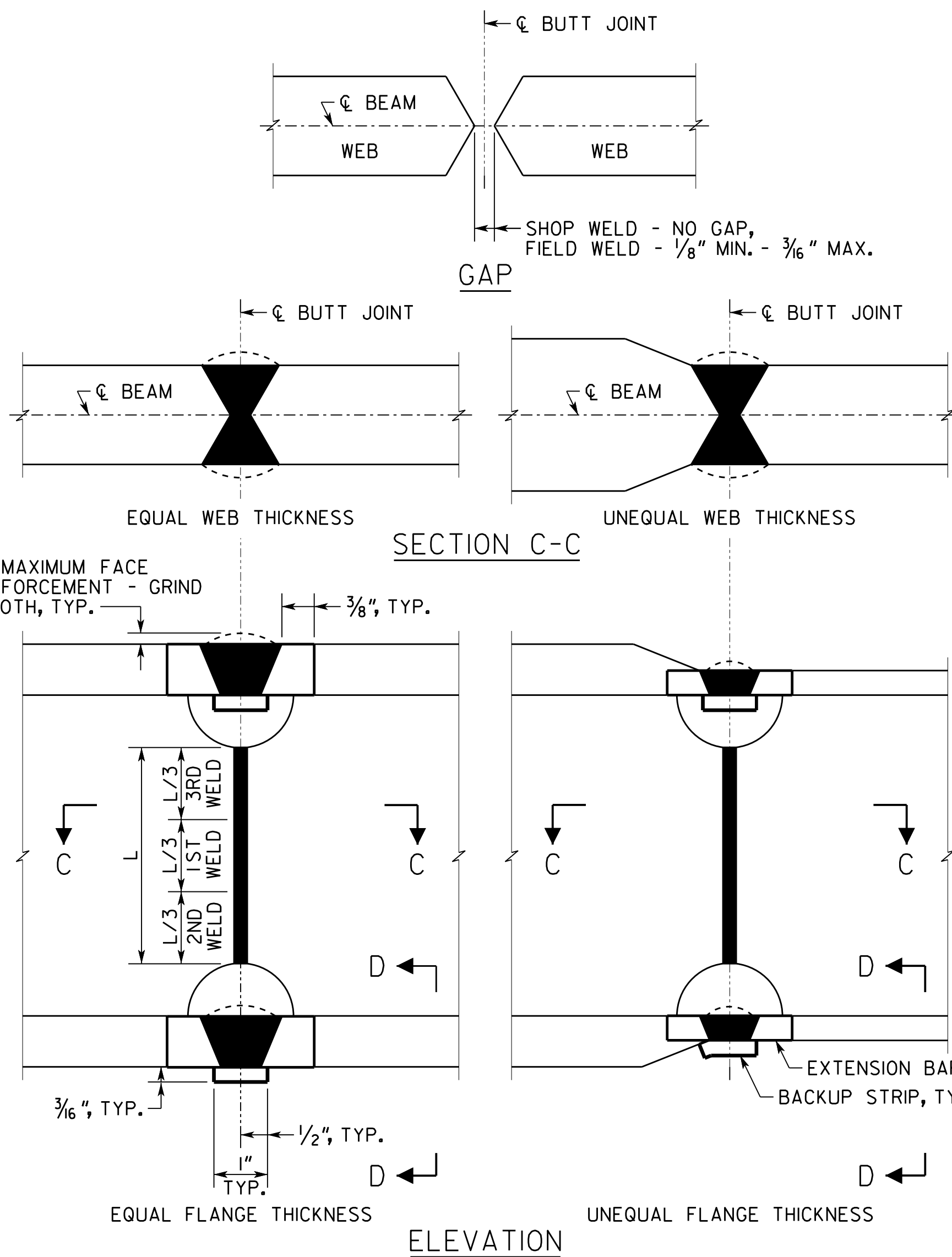
WELD PROCEDURES

FOR DETAILS NOT SHOWN, SEE REMAINING PORTIONS OF THIS SHEET

BOTTOM FLANGES - W36

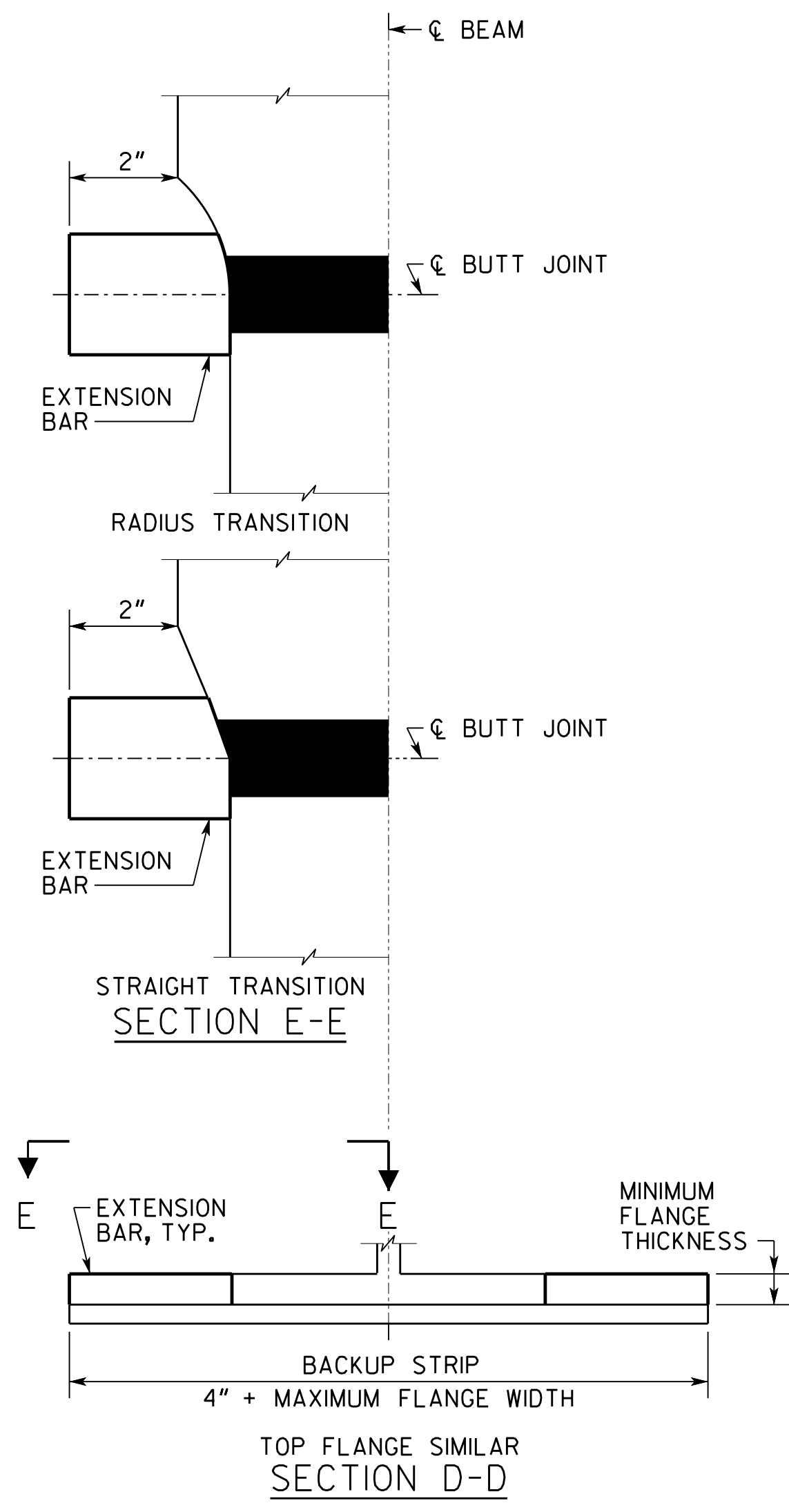
NOTES

- 1) THE TERM "SPLICE" AS USED IN THESE NOTES AND GEORGIA DOT SPECIFICATIONS IS SYNONYMOUS WITH THE TERM "BUTT JOINT".
- 2) THE CONTRACTOR SHALL SUBMIT HIS PROPOSAL FOR ALTERNATE LOCATIONS OF SPLICES TO THE BRIDGE ENGINEER, WHOSE WRITTEN APPROVAL SHALL BE REQUIRED BEFORE THE WORK PROCEEDS. SEE SUB-SECTION 501.1.03.B.6 OF THE GEORGIA DOT SPECIFICATIONS.
- 3) DETAILS ARE SYMMETRICAL ABOUT ϕ SPLICE AND ϕ BEAM UNLESS NOTED. ϕ BEAM EQUALS ϕ GIRDER.
- 4) THE BOTTOMS OF THE TOP FLANGES SHALL BE ALIGNED.
- 5) SPLICE SHALL BE FURNISHED IN CONFORMANCE WITH SECTION 501 OF THE GEORGIA DOT SPECIFICATIONS.
- 6) WORK SHALL BE PROTECTED FROM MOISTURE DURING WELDING AND UNTIL PARTS WELDED HAVE COOLED TO ATMOSPHERIC TEMPERATURE. LEAVE COPE HOLES OPEN.
- 7) WHEN WELDING ASTM A709 GRADE 36 AND ASTM A709 GRADE 50, WELDING SHALL BE DONE USING SPECIFICATIONS OF ASTM A709 GRADE 50.
- 8) ONLY E70XX (EXCLUDING E7014 AND E7024) LOW HYDROGEN ELECTRODES SHALL BE USED FOR MANUAL SHIELDED METAL ARC WELDING.
- 9) SEQUENCE OF WELDS: FIRST - WEB, SECOND - BOTTOM FLANGE, THIRD - TOP FLANGE. USE TWIN ARC TECHNIQUE ON WEB AND BOTTOM FLANGE.
- 10) AFTER WELDING REMOVE THE BACKUP STRIPS AND EXTENSION BARS. WELDS SHALL BE GROUND SMOOTH. GRINDING SHALL BE DONE PARALLEL TO THE LENGTH OF THE BEAM. CHIPPING WILL NOT BE ALLOWED. ANY VISUAL IMPERFECTIONS SHALL BE REPAIRED BY WELDING AND GRINDING AS STATED ABOVE.
- 11) AFTER REMOVING BACKUP STRIPS AND EXTENSION BARS CLEAN AND PAINT THE SPLICE AREA IN ACCORDANCE WITH GEORGIA DOT SPECIFICATION SECTION 535.



SECTION C-C

ELEVATION



SECTION D-D

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

THICKNESS OF THICKEST PART AT POINT OF WELDING

THICKNESS	TEMPERATURE	
	ASTM A 709 GRADE 36	ASTM A 709 GRADE 50
ZERO TO 3/4" INCLUSIVE	NONE	NONE
OVER 3/4" TO 1 1/2" INCLUSIVE	150° F	50° F
OVER 1 1/2" TO 2 1/2" INCLUSIVE	225° F	150° F
OVER 2 1/2" TO 4" INCLUSIVE	300° F	225° F

BRIDGE NO. 1		GEORGIA	
DEPARTMENT OF TRANSPORTATION		ENGINEERING DIVISION-OFFICE OF BRIDGES AND STRUCTURES	
BUTT JOINT DETAILS		X	
NO SCALE		X	
DRAWING NO. 35-0001		DESIGNED X	
BRIDGE SHEET X OF X		DRAWN JJM	
		CHECKED X	
		DESIGN GROUP X	
		REVIEWED DLC/WMD	
		APPROVED BFR	

1 INCH WHEN PRINTED FULL SIZE